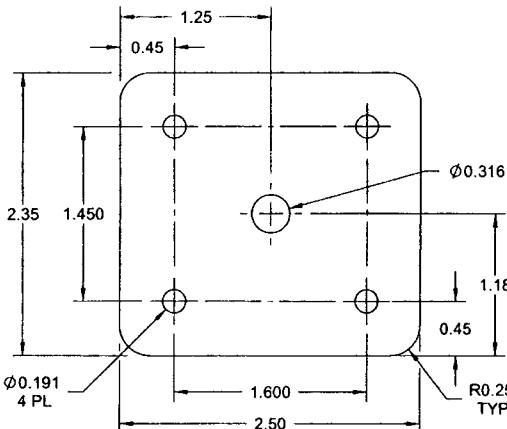


D3622-11 BALL STUD

D4109-3 PLATE

D4109-043 DOUBLER ASSEMBLY



D4109-3 PLATE

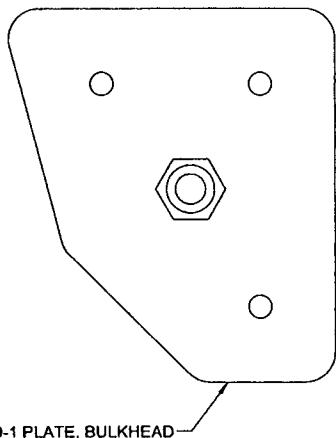
10/06/2010

RELEASED
2010-09-23
M

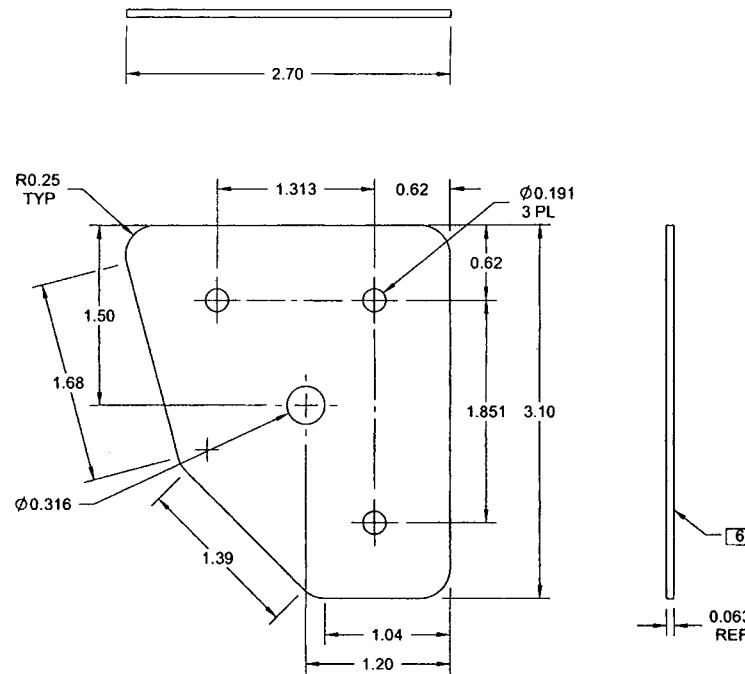
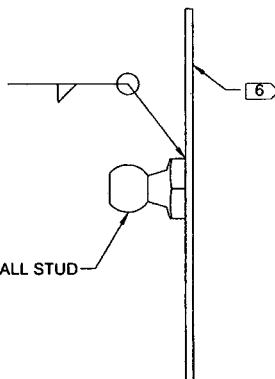
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT-043: 0.12 lbs
- 8) WELD PARTS PER QSI 004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>13</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>14</i>	D4109	SHEET 3 OF 3
APPROVED	<i>14</i>	TITLE	SCALE
DE APPR.	<i>14</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-1 PLATE, BULKHEAD

1062504

RELEASED
2010-09-23

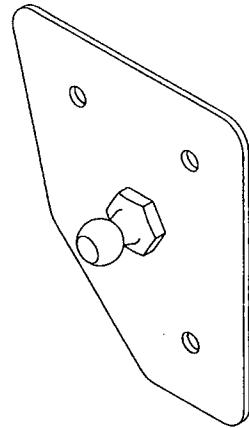
NOTES:

NOTES:

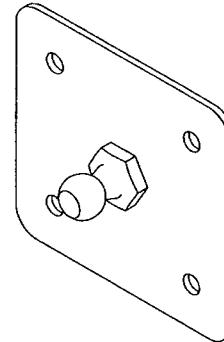
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.14 lbs
- 8) WELD-PARTS PER QSI.004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>B</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>S</i>	D4109	SHEET 2 OF 3
APPROVED	<i>S</i>	TITLE	SCALE
DE APPR.	<i>S</i>	DOUBLER ASSEMBLY	
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Qty	Qty	Part Number	Description
1	041	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
		D4109-043	DOUBLER ASSEMBLY
1		D4109-1	PLATE, BULKHEAD
1		D4109-3	PLATE
1	1	D3622-11	BALL STUD



D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-043 DOUBLER ASSEMBLY

W0
62504

RELEASED
2010-08-23
MP

A	NEW ISSUE		JP	10.07.20
REV.	DESCRIPTION		BY	DATE
DESIGN	JP			
DRAWN		JP		
CHECKED		JP		
MFG. APPR.		JP		
APPROVED		JP		
DE APPR.		JP		
DATE	10.07.20		SCALE	NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4109 SHEET 1 OF 3

TITLE DOUBLER ASSEMBLY

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Picklist Print

October 1, 2010 10:03:08 AM

Page 1

Work Order ID: 62504



A standard 1D barcode is located at the top of the page, consisting of vertical black lines of varying widths on a white background.

Parent Item: D4109-043

Parent Item Name: Doubler Assembly

Start Date: 10/01/10

Required Date: 10/04/10

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Start Qty: 2.00

Start Oty: 2.00

Required Qty: 2.00

Required Qty: 2.00

Work Order ID 62504

October 1, 2010 10:03:09 AM



Page 2

Item ID: D4109-043

Accept



Setup Start



Revision ID:

Item Name: Doubler Assembly

Stop



Start Date: 10/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/04/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130

Identify as per dwg & Stock Location: 130

Packaging

Memo

Set Up/
Run Hours

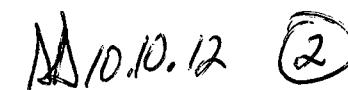
Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

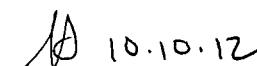


140



QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00



Work Order ID 62504

October 1, 2010 10:03:09 AM



Page 1

Item ID: D4109-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 10/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/04/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4109	A

100 Weld per dwg A/R S.S. rod Batch: 4114649 0.00

Large Fab

Memo

0.00

SM 10/10/02 2x

Large Fab

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

2x 10.10.04

QC

Quality Control

Memo

0.00

120



QC5- Inspect part completeness to step on W/O

0.00

8.10.10.04

QC

Quality Control

Memo

0.00

2x